

Work Order ID 59342

June 1, 2010 7:47:09 PM



Page 1

Item ID: D4123-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 02/06/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 16/06/2010 Req'd Qty: 16.00



Customer:

Reference: *Jun/10 06:01*

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4123

A

100

0.00



Doosan

Memo

0.00

Doosan Lathe

turn as per dwg and folio FA936

DWG REV: A

FOLIO REV: N/A

SL 10/06/04

(16)

DEBURR

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SL 10/06/04

Work Order ID 59342

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Required Date: 16/06/2010 Req'd Qty: 16.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

Jun 10 10:00:07

150



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

16-6-78 (16)

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/07

U 10-06-07

Picklist Print

June 1, 2010 7:47:08 PM

Page 1

Work Order ID: 59342

Parent Item: D4123-1

Parent Item Name: Bushing

Comments: IPP REV:A NEW ISSUE 10-06-01 JLM VERIFIED BY:DD

Start Date: 02/06/2010

Required Date: 16/06/2010

Start Qty: 16.00

Required Qty: 16.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R1.000		Purchased	No			100	f	27.9500	0.085	1.431579			



303 Round Bar 1.00



Location

Loc Qty

Loc Code

MAT028

27.95

113325

27.95

1.431579

[Signature]
10-06-01

DART AEROSPACE LTD		Work Order: 59342
Description: bushing		Part Number: DH123-1
Inspection Dwg: DH123	Rev: A	Page 1 of 1

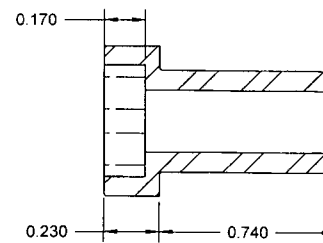
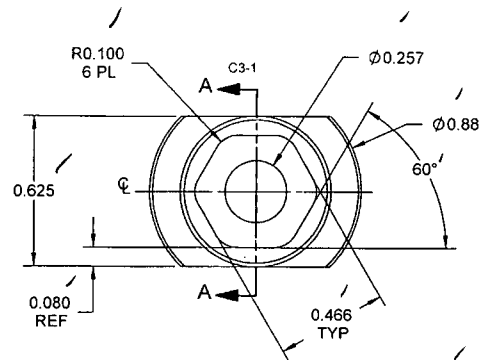
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

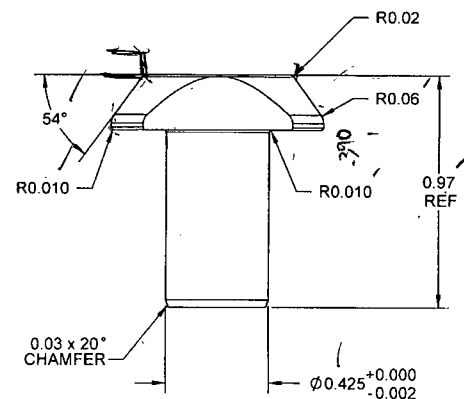
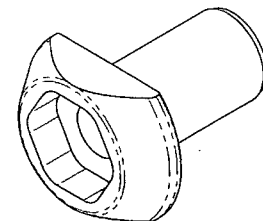
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.100	$\pm .010$	5.100	✓			
.625	$\pm .010$.626	✓			
.080	$\pm .010$.079	✓			
.466	$\pm .010$.467	✓			
60°	$\pm .5°$	60°	✓			
.88	$\pm .030$.880	✓			
Ø .257	$\pm .006$ $\pm .001$.258	✓			
Γ .020	$\pm .030$.020	✓			
Γ .06	$\pm .030$.060	✓			
54°	$\pm .5°$	54°	✓			
Γ .010	$\pm .010$.010	✓			
.03x20°	$\pm .030 \pm .5°$.03x20°	✓			
.425	$\pm .002$.4236	✓			
.97	$\pm .030$.971	✓			
.170	$\pm .010$.172	✓			
.230	$\pm .010$.232	✓			
.740	$\pm .010$.740	✓			

Measured by: SL	Audited by: [Signature]	Prototype Approval: N/A
Date: 10/06/04	Date: 10-06-07	Date: N/A

Rev A	Date	Change New Issue	Revised by KJ/JLM	Approved
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SECTION A-A D6-1



D4123-1 BUSHING

w/o 59342

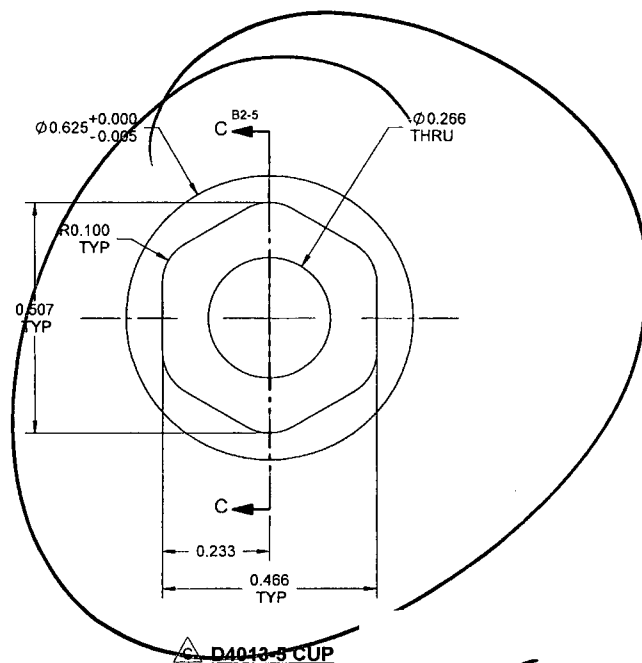
RELEASED
2010-05-31
MJP

NOTES:

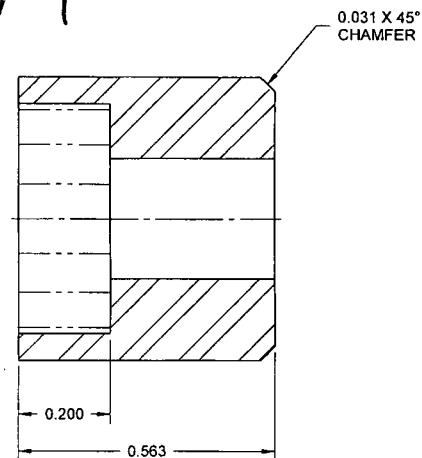
- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	RF	10.05.26
DESIGN	DS		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.05.26		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4123	REV. A
TITLE BUSHING	SHEET 1 OF 1
SCALE NTS	
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Reb only.



SECTION C-C D6-5

RELEASED
2009-11-24
MD

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR PER ASTM A276 REF. DART SPEC. M304R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.03 lbs EACH

USE D4013-5
Cup Prog For "Hex"
PATTERN
See Attached

DESIGN	18	DART AEROSPACE LTD	
DRAWN	18	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D4013	SHEET 5 OF 5
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	WEARPLATE ASSEMBLY	NTS
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